

Date: Monday, 04/05/2009 1:45:17 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL TUNNEL LOWER
Job Number : 47672E	
Estimate Number : 13603	
P.O. Number :	Part Number : D38227 GY
This Issue : 04/05/2009 S.O. No. :	Drawing Number : D3822-7
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision : B
Previous Run : 47304E	Material : MKYD6185S080P362015
Written By :	Due Date : 11/05/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.05.09</u>	29
Comment : Est. Rev. A New Issue 08.09.25 DL Rev B Dwg. Update. 09/02/09 DL verified by:DD	POSITIVE RECALL

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P352068	6185 Kydex .080 steel grey
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MP 09/05/25



Comment: Qty.: 5.4170 sf(s)/Unit Total : 5.4170 sf(s)
6185 Kydex .080"

M111807

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/05/21

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/05/21 BB x2

4.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-7 and folio FTA 029) using tool DT 9396

Dwg. Rev. B

Folio Rev. B

BB 09/05/21 X2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/05/2009 1:45:17 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL LOWER

Job Number: 47672E

Part Number: D38227

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 07/05/21 X2

6.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

09.05.21

7.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

09.05.21

8.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

09.05.21

9.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

09.05.21

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPO 47672

POSITION

EFFECTIVE DATE

DATE

AUTH

DATE



09/05/26

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

MF 09-05-25

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	47672E
Description:	Part Number:	D3822-7
Inspection Dwg: D3822-7 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u> </u> " N/A.				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: JB

Date: 09/05/21

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20"	0.030"	0.224"	✓			
0.30"	0.030"	0.317"	✓			
2.0"	0.100"	2.0"	✓			
0.040"	M, N	0.053"	✓			

Measured by: Sh

Date: 09.05.21

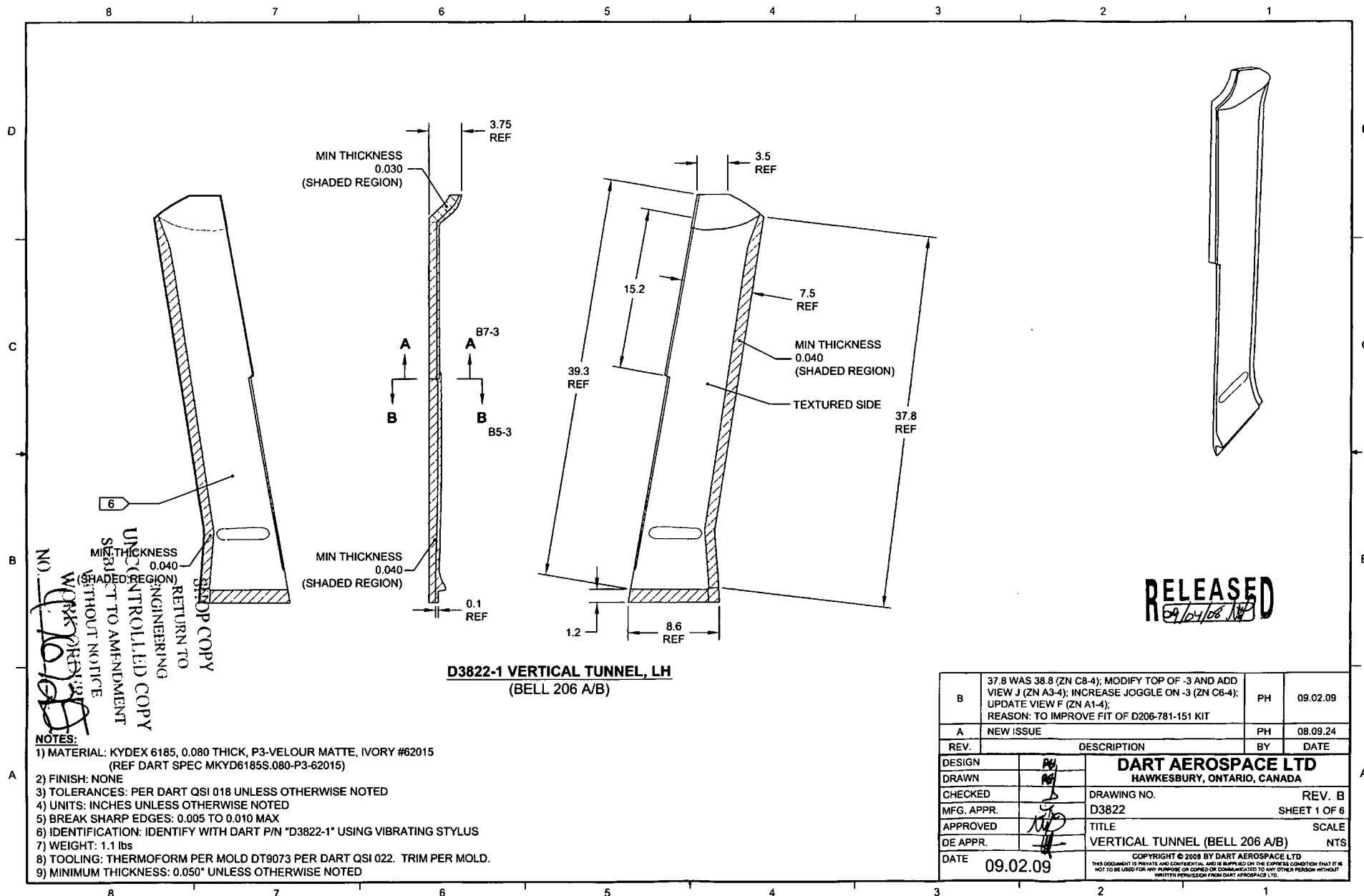
Audited by:

Date: 09.05.25

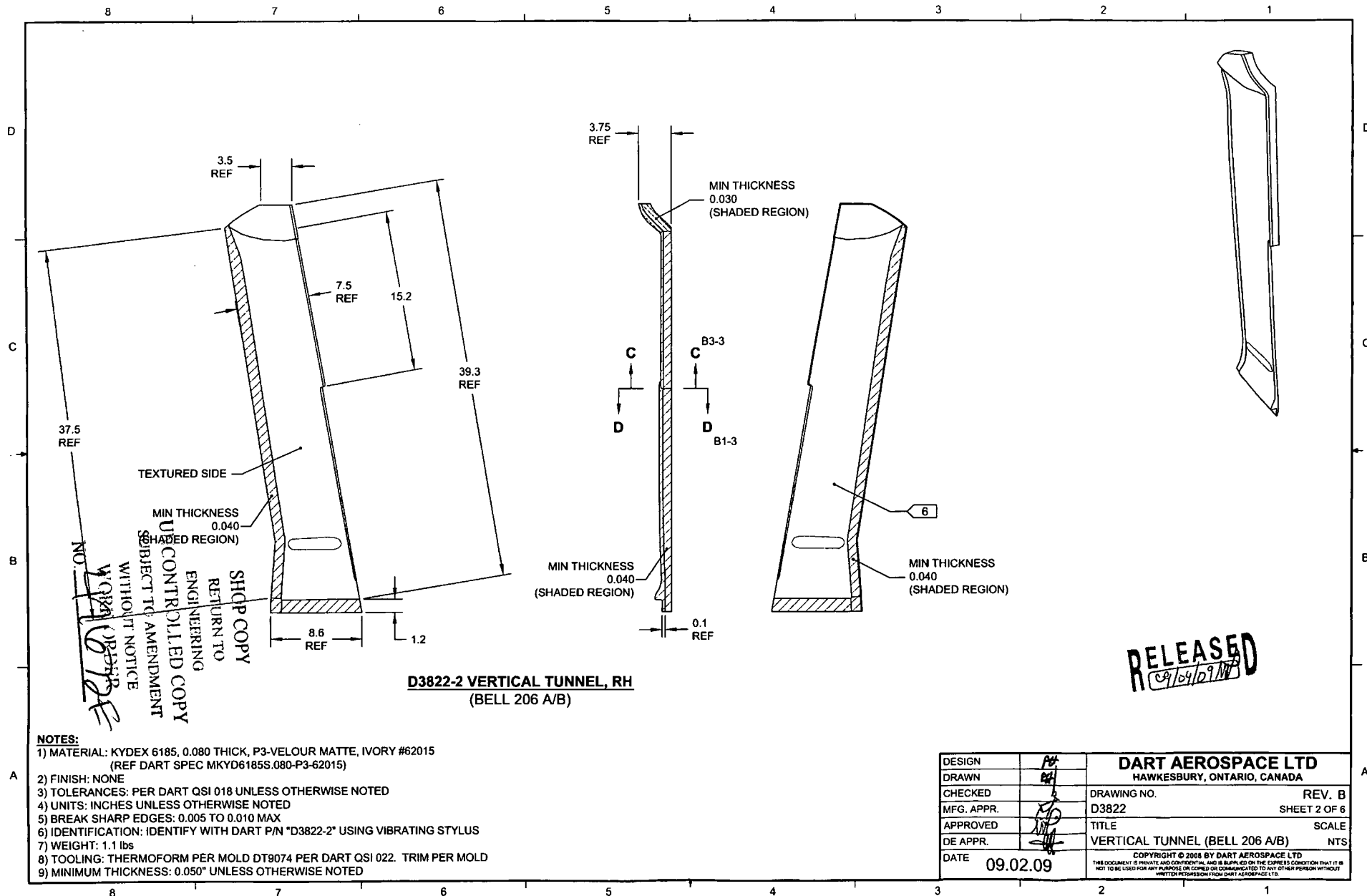
Prototype Approval:

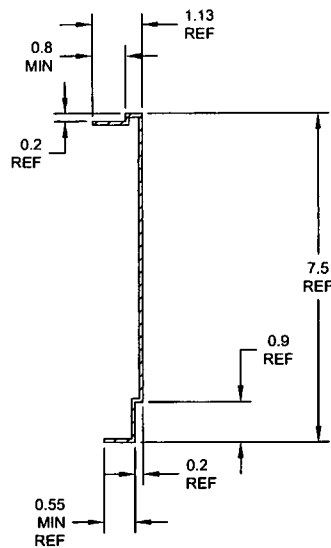
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



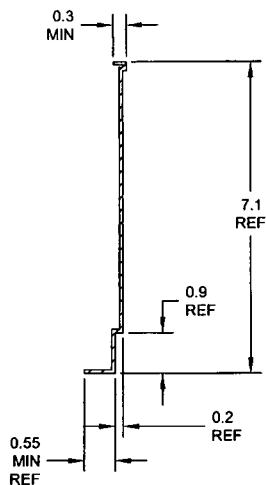
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C8-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B D3822 SHEET 1 OF 6 TITLE SCALE VERTICAL TUNNEL (BELL 206 A/B) NTS <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	PA		
CHECKED	PA		
MFG. APPR.	MP		
APPROVED	MP		
DE APPR.	MP		
DATE	09.02.09		





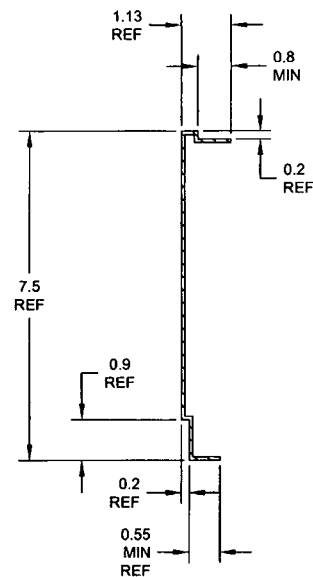
SECTION A-A

C6-1



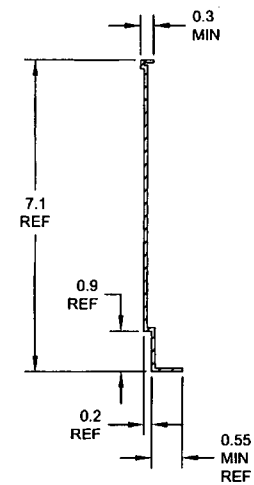
SECTION B-B

C6-1



SECTION C-C

C4-2



SECTION D-D

C4-2

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01/01/09

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DRAWN	AW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AW	DRAWING NO.	REV. B
MFG. APPR.	AW	D3822	SHEET 3 OF 6
APPROVED	AW	TITLE	SCALE
DE APPR.	AW	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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8 7 6 5 4 3 2 1

D

C

B

A

37.8
REF



MIN THICKNESS
0.035
(SHADED REGION,
BOTH SIDES)

2.4
REF

VIEW F
A1-4

VIEW J
A3-4

6.7
REF

MIN THICKNESS
0.020
(SHADED REGION)

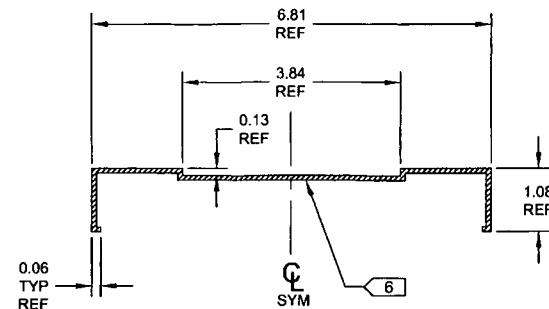
0.5
MIN



E

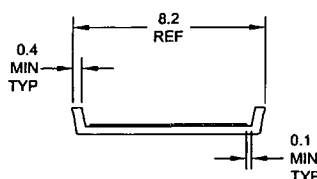
E C2-4

TEXTURED SIDE



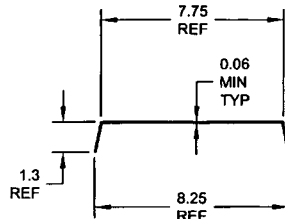
SECTION E-E
SCALE 5X

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9/10/09



D5-4

VIEW J
SCALE 2X



B7-4

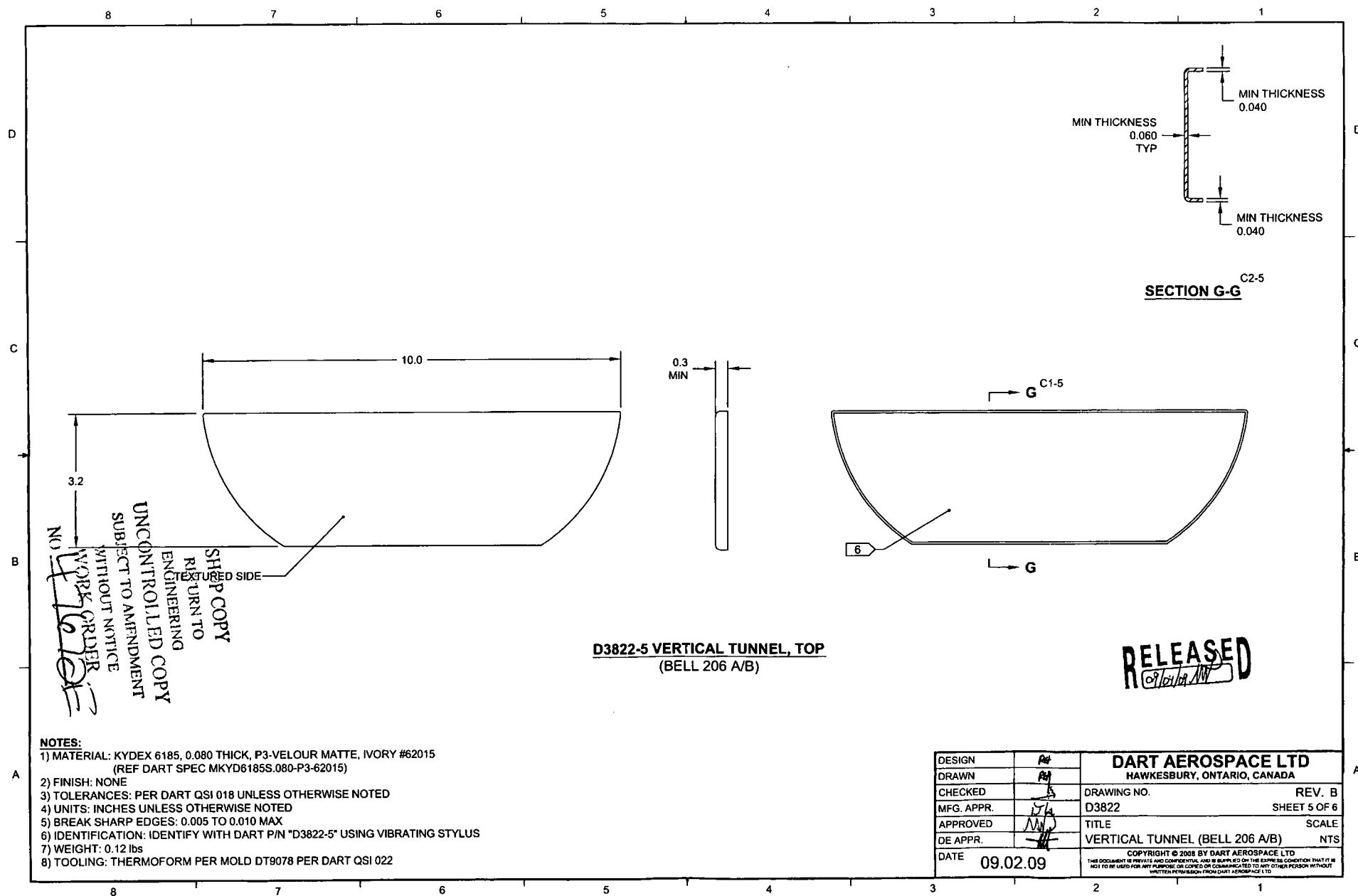
VIEW F
SCALE 2X
(ROTATED 90° CW)

D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

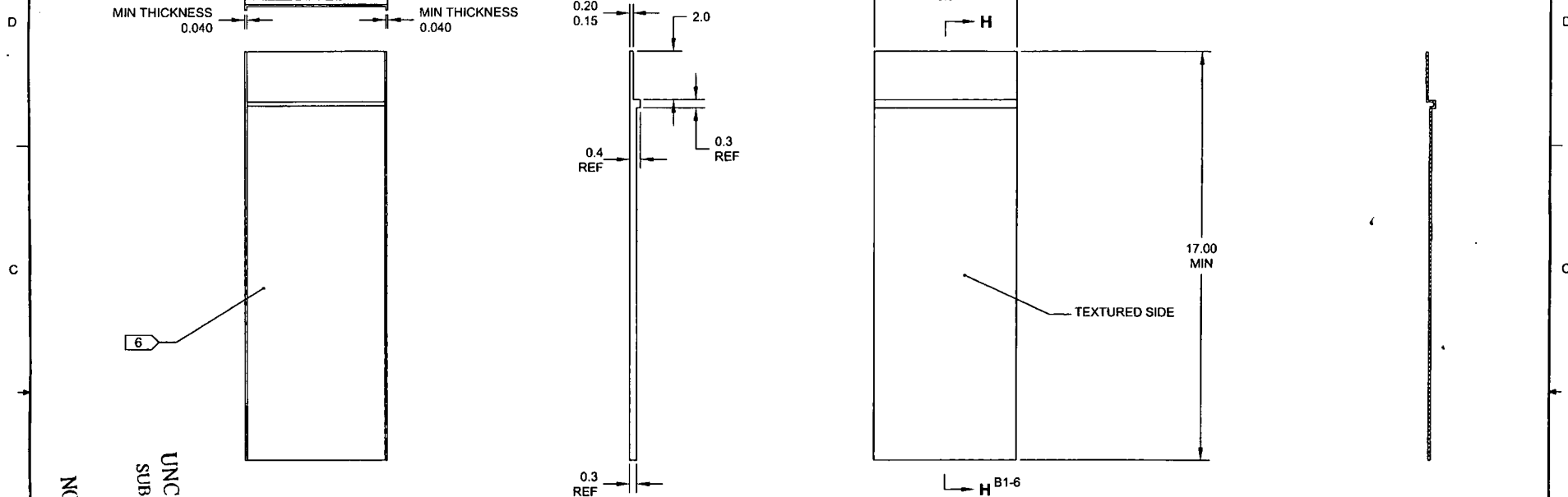
- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 1.1 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

DESIGN	PA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PA		
CHECKED	PA	DRAWING NO.	REV. B
MFG. APPR.	PA	D3822	SHEET 4 OF 6
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DE APPR.	PA	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1



D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

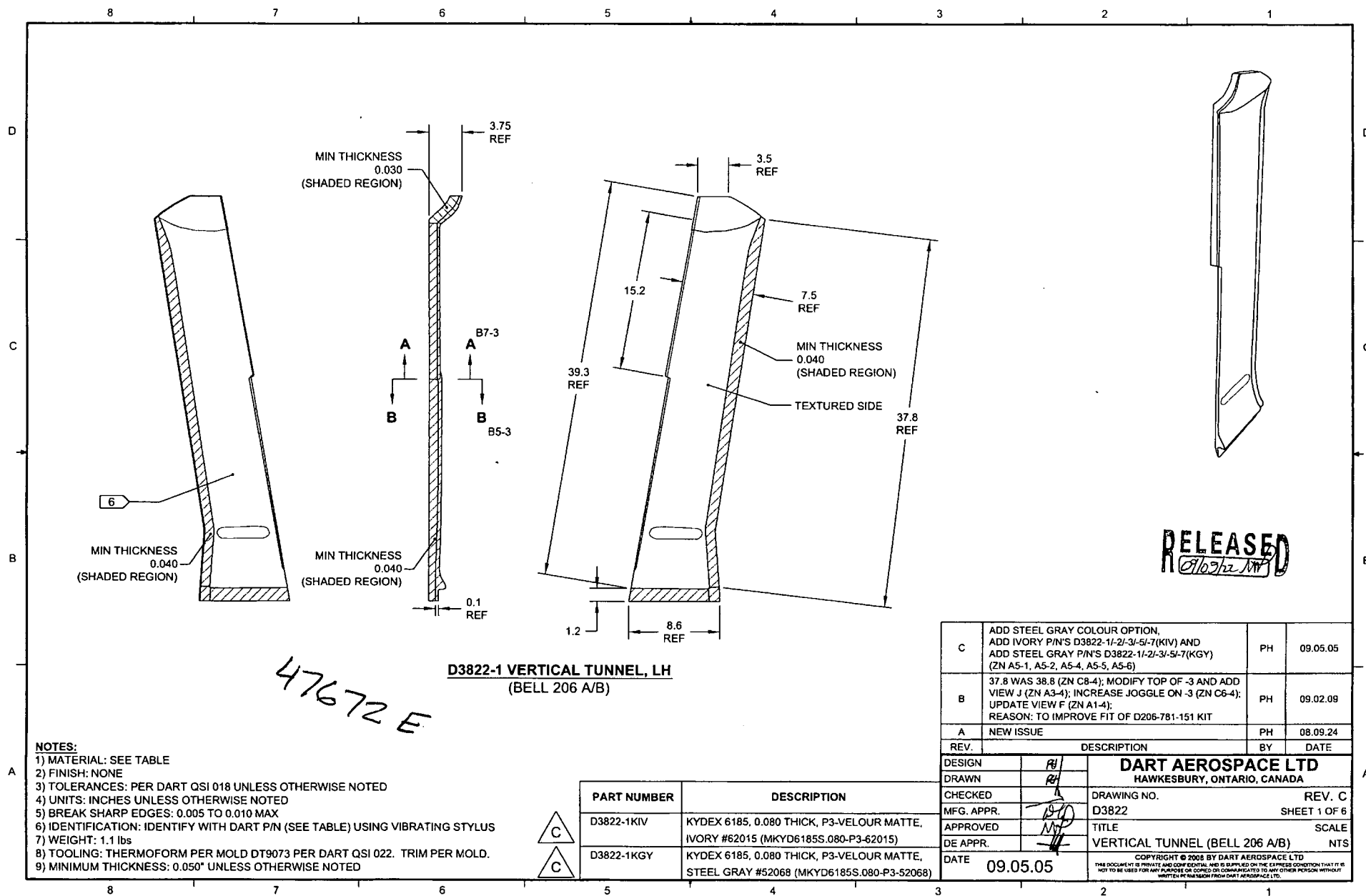
SECTION H-H B3-6

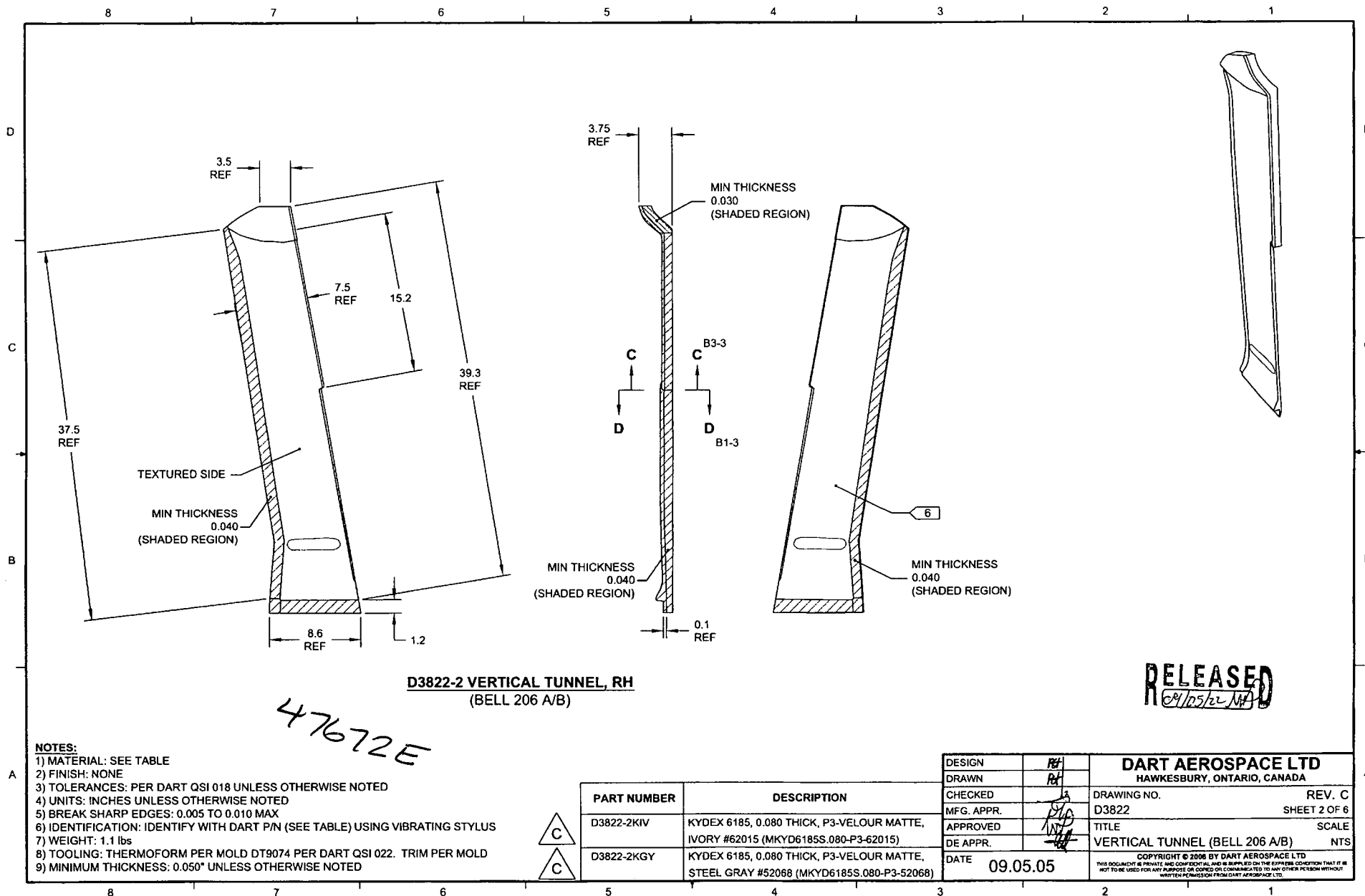
RELEASED
6/24/09

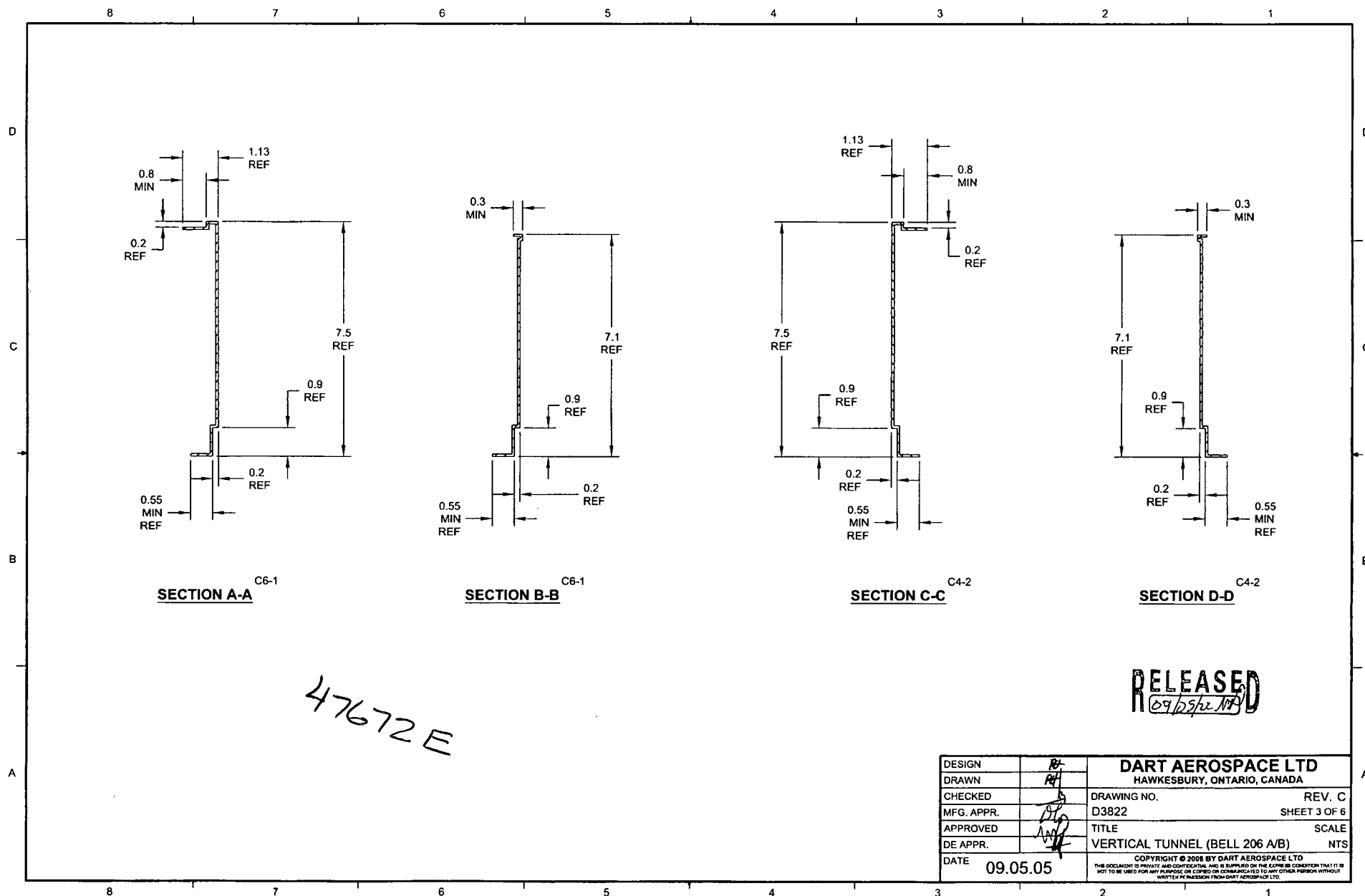
- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-7" WITH VIBRATING STYLUS
 - 7) WEIGHT: 0.36 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
 - 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

DESIGN	AB	DART AEROSPACE LTD	
DRAWN	BA	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3822	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B)	NTS
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8 7 6 5 4 3 2 1







DESIGN	BT	DART AEROSPACE LTD	
DRAWN	BT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BT	DRAWING NO.	REV. C
MFG. APPR.	BT	D3822	SHEET 3 OF 6
APPROVED	BT	TITLE	SCALE
DE APPR.	BT	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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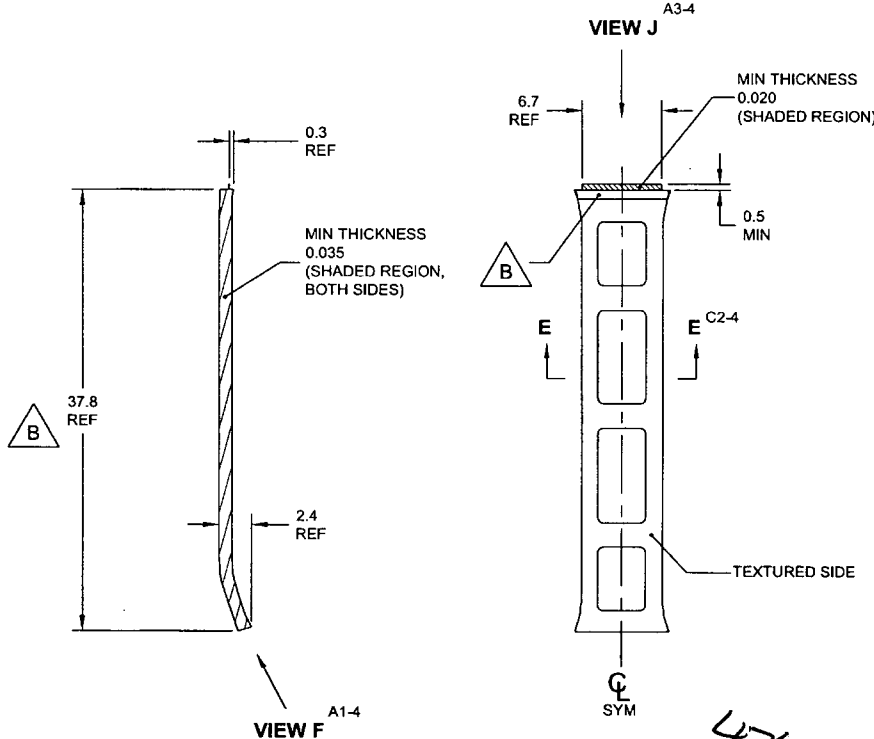
8 7 6 5 4 3 2 1

D

C

B

A

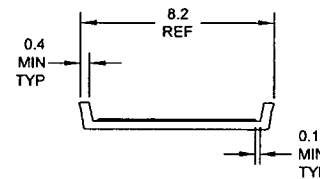


D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

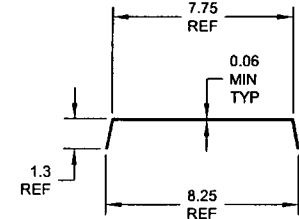
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)



VIEW J
SCALE 2X

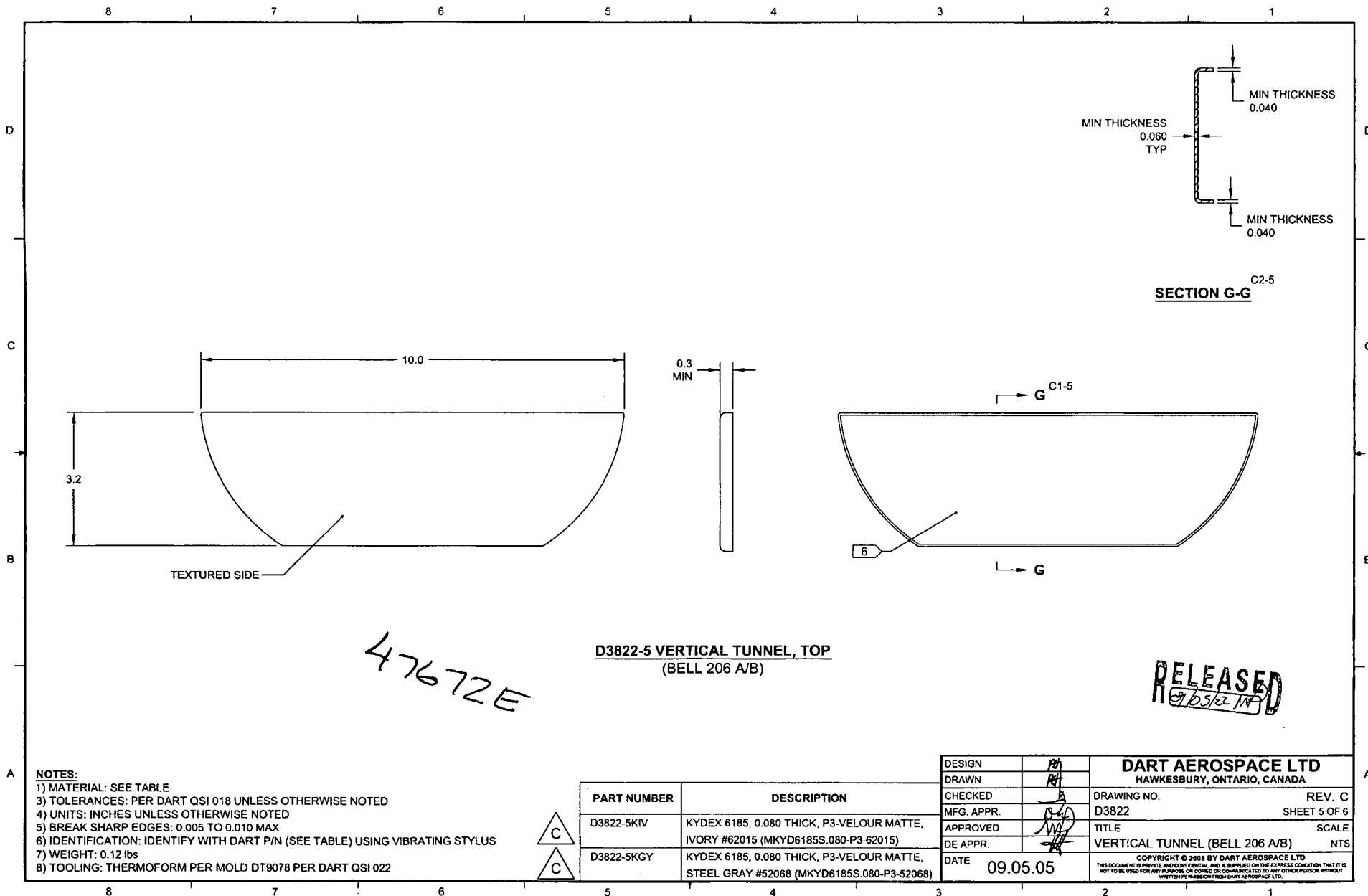


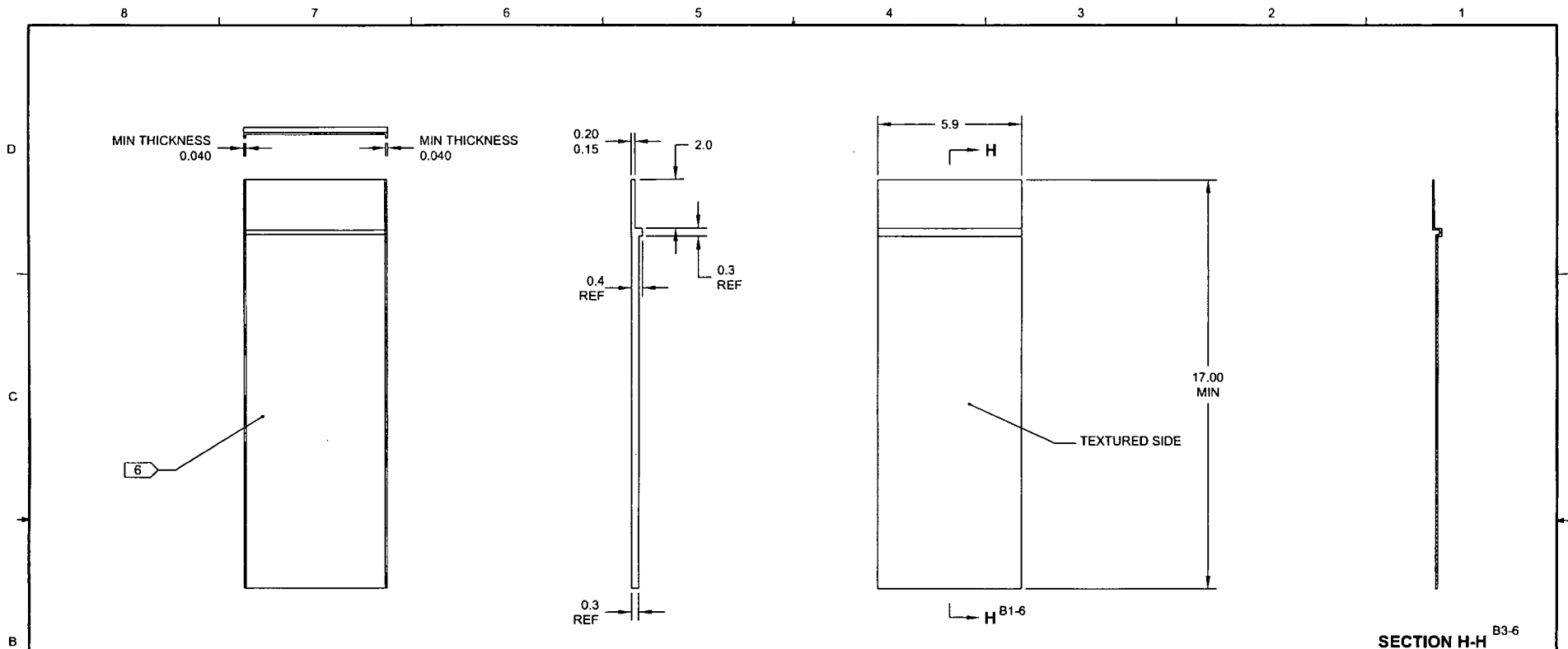
VIEW F
SCALE 2X
(ROTATED 90° CW)

RELEASED
09/05/22

DESIGN	PA	DART AEROSPACE LTD
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3822 SHEET 4 OF 6
APPROVED		TITLE SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B) NTS
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8 7 6 5 4 3 2 1





D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

SECTION H-H B3-6

RELEASED
9/15/22-MP

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3822	SHEET 6 OF 6
APPROVED	PH	TITLE	SCALE
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